

# Work Order ID 81502

**\*81502\***

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Item ID: D2873-043 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Nut Plate Assembly  
 Start Date: 14/03/2012 Start Qty: 20.00 **\*20\*** Cust Item ID:  
 Required Date: 28/03/2012 Req'd Qty: 20.00 **\*20\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/14 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D2873	Rev A								
100	BAND SAW	0.00							
<b>*100*</b>									
Bandsaw	<b>Memo</b>	0.00							
Jcaspa Bandsaw	Cut blanks: 1.000" x 0.375" x 3.700" long		SL	12/04/02		20	0		
110	HAAS CNC VERTICAL MACHINING #1	0.00							
<b>*110*</b>									
HAAS 1	<b>Memo</b>	0.00							
HAAS CNC vertical machine #1	Machine as per Folio FA and Dwg D2873 Identify as D2873-3 Dwg Rev <u>A</u> Folio Rev <u>AA</u>		SL/PO	12/04/07		20	0		
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*120*</b>									
QC	<b>Memo</b>	0.00							
Quality Control			SL/PO	12/04/07		20	0		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00	B.A	12/04/08		20	0		
140 <b>*140*</b> Small Fab Small Fab	Small Fab  Memo 1-Deburr 2- C'sink as per Dwg D2873	0.00  0.00				20x	0		2/04/10
150 <b>*150*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00	Szbelko			Card 720			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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 Start Date: 14/03/2012 Start Qty: 20.00 **\*20\*** Cust Item ID:  
 Required Date: 28/03/2012 Req'd Qty: 20.00 **\*20\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*160*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
170	QC3- Inspect Part Finish	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									
180	Small Fab	0.00							
<b>*180*</b>									
Small Fab	Memo	0.00							
Small Fab	1-Assemble as per Dwg D2873 2-Identify as D2873-043								

*m* 12 '04 11 (20)

*20x* *h* 12/04/11

*20x* *h* 12/04/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Work Order ID 81502

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Item ID: D2873-043

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Nut Plate Assembly

Start Date: 14/03/2012 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 28/03/2012 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

**\*190\***

QC

Memo

0.00

Quality Control

(20)

12/04/11

200

Identify as per dwg & Stock Location: *\* tube*

0.00

**\*200\***

Packaging

Memo

0.00

Packaging

(20)

12/04/11

210

QC21- Final Inspection - Work Order Release

0.00

**\*210\***

QC

Memo

0.00

Quality Control

12/4/12

12-04-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 81502

\*81502\*

Parent Item: D2873-043

\*D2873-043\*

Parent Item Name: Nut Plate Assembly

Start Date: 14/03/2012

Required Date: 28/03/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A05.09.13New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS21075L5

Purchased

No

100

Each

26.0000

3

60

**\*MS21075L 5\***

\*\*

Nut Plate

Location

Loc Qty

Loc Code

ST302

26

120662

26

M6061T6B0.375X01.00

Purchased

No

180

f

27.0520

0.3083

6.490526

0

**\*M6061T6B0 375X01 000\***

\*\*

6061T6 BAR .375 x 1.00

Location

Loc Qty

Loc Code

MAT001

2.292

118641

2.292

MAT002

24.76

119346

12

120603

0.76

120866

12

MS20426AD4-6

Purchased

No

180

Each

1,962.000

6

120

**\*MS20426AD4-6\***

\*\*

Rivet

Location

Loc Qty

Loc Code

ST317

1962

110139

187

118510

853

119436

922

12/04/11

1121162 (Box)

SL 12/04/12

6.5

120

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	81502
<b>Description:</b> Radius Block		<b>Part Number:</b>	D2873-3
<b>Inspection Dwg:</b> D2873 <b>Rev:</b> A		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
                         
 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3.500	✓		Vern	SLY
2.000	+/-0.010	2.000	✓		-	
0.750	+/-0.010	.750	✓		-	
1.000	+/-0.010	1.000	✓		-	
0.250	+/-0.010	.250	✓		-	
1.000	+/-0.010	1.000	✓		-	
2.000	+/-0.010	2.000	✓		-	
3.000	+/-0.010	3.000	✓		-	
Ø0.128	+0.005/-0.001	.129	✓		-	
0.359	+/-0.010	.359	✓		-	
Ø0.316	+0.006/-0.001	.316	✓		-	
1.000	+/-0.010	1.005	✓		-	
0.250	+/-0.010	.250	✓		-	
0.061	+/-0.010	.059	✓		-	
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	.229 x .126	✓		-	

<b>Measured by:</b>	<i>[Signature]</i>	<b>Audited by:</b>	A.A	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	12/04/05	<b>Date:</b>	12/04/08	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue      P/O D2873-043	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

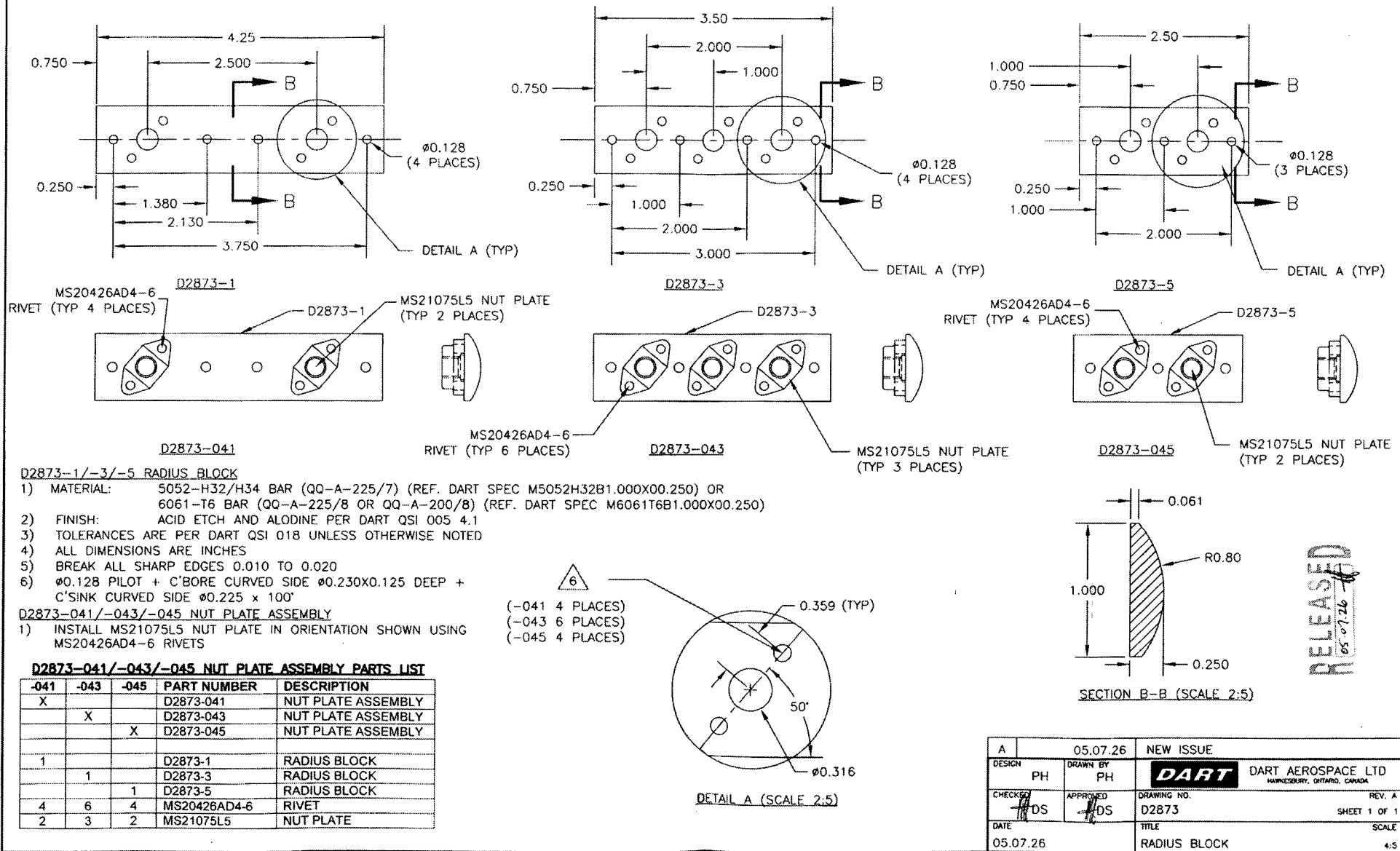
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 01502 MCT  
 12/03/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries